

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.21**WELDING WITNESS REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WWR-000146**Date Inspected:** 19-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**Witness:** **Procedure Qualification Record**  
**Welding** **NDT****Welder Qualification** **Fracture Critical**  
**Mechanical Testing, describe:** side bends, reduction section  
tension and macro etching**Index Lot #:** B71-006-07a**Witness Lot #:** B49-010-07**Bridge No:** 34-0006**Component:** Bid 52, 55 Tower and Girder**Welder:** Jiang Xian Hu**ID #:** N/A**Joint Description:** B-U2a-GF

N/A

**WPS ID #:** PWPS-B-T-2231-T-1

N/A

**Base Metal:** A-709-50F2

N/A

**PQR ID #:** HPS200710

N/A

**Thickness:** 26 mm

N/A

**Process:** FCAW-G

N/A

**Electrode Spec/Class:** AWS-5.20/E71-T1

N/A

**Positions:** 1-G

N/A

**Backing Material:** Ceramic JN-401

N/A

**CWI:** Liu Liu and Hang Wei

N/A

**Average Amps:**

N/A

**AWS Code:** AWS D1.5 -02

N/A

**Average Volts:**

N/A

**Applicable Sec:** AWS 5.13

N/A

**Travel Speed:**

N/A

**Heat Input:**

N/A

**Preheat:**

N/A

**Summary of Items Observed:**

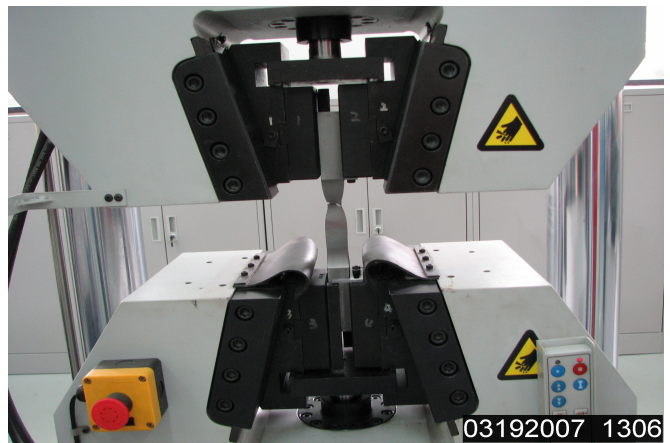
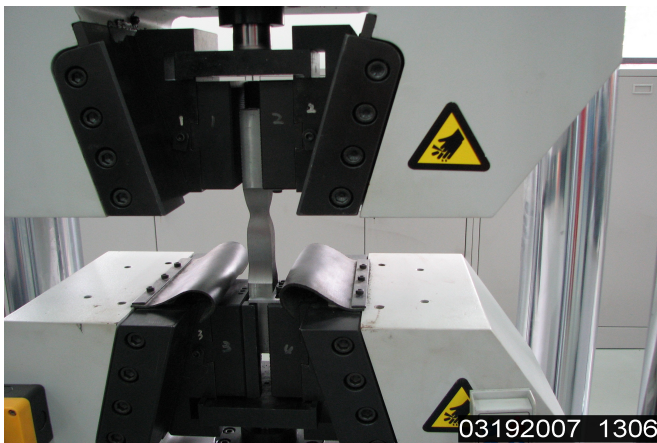
Caltrans Quality Assurance (QA) Inspector was present as requested by ZPMC to witness the mechanical testing for procedure qualification (PQR) HP200710 using flux core arc welding (FCAW), using 1.4mm diameter electrode, specification AWS A5.20 and classification E71T1-1 requirements. The mechanical testing was performed in accordance with AWS D1.5 section 5.13, figure 5.3. The weld test specimens appeared to comply with the contract documents.

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## WELDING WITNESS REPORT

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### Summary of Conversations:

At 1000 hours. ZPMC Quality Assurance Manager, Mr. Lui Lui met with Caltrans QA and stated that ZPMC would be performing mechanical for PQR HP200710 at 1300 hours. At 1300 hours Caltrans witnessed the mechanical testing at ZPMC testing facility.

### Observed welding,testing or results:

is in general conformance with the contract requirements.

is not in conformance with the contract requirements.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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**Inspected By:** Hasler,Mike

Quality Assurance Inspector

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**Reviewed By:** McClary,David

QA Reviewer